

Date: Monday, 4/30/2007 7:22:14 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 SKIDTUBE "I" BEAM
Job Number : 32098	
Estimate Number : 10346	
P.O. Number : <u>N/A</u>	Part Number : D2596
This Issue : 4/30/2007 S.O. No. : <u>NA</u>	Drawing Number : D2596 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : LANDING GEAR	Drawing Revision : C
Previous Run : 31517	Material : <u>N/A</u>
Written By : <u>DP 7-5-8</u>	Due Date : 5/10/2007 Qty: <u>5</u> Um: Each
Checked & Approved By : <u>DP 7-5-8</u>	
Comment : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n - 'I' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	<u>B 25 751</u>

JD-7-5-8

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

JD 7-5-8

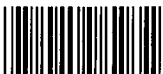
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid Etch and Alodine per QSI 005 4.1

JD 7-5-8

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-9

(5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP 7-5-9

(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/05/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/30/2007 7:22:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 32098

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

⑤
R 105110

Job Completion



U 07-05-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

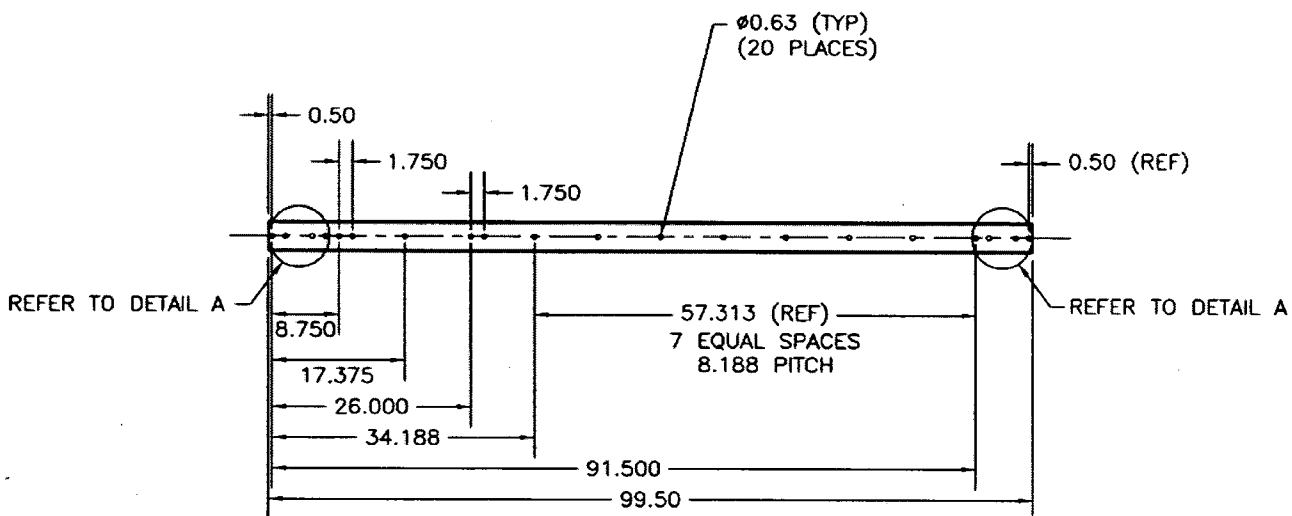
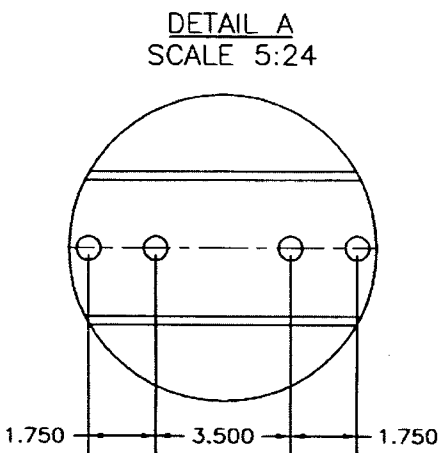
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.09.17 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	SHEET 1 OF 1	
98.09.14	D2596		
	TITLE	SCALE	
	205 WEB	1:24	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32098